

Date

Thursday, 12/06/2008 9:46:02 AM

User:

Linda Lacelle

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number **Estimate Number** : 39826

: 10930

P.O. Number

This Issue : 12/06/2008 Prsht Rev.

: NC First Issue

Previous Run

: // : 39661

Type

S.O. No. :

: MACHINED PARTS

Part Number

Drawing Name

: D2057 : D2057 PRELIM

Drawing Number Project Number

: N/A : PRELIM

: PLUG

Drawing Revision Material

Due Date : 19/06/2008 Qty:

100 Um: Each

Written By

Checked & Approved By

Comment

Make in Cobra KJ : Est D 02.08.22

Est Rev:E 08-05-27 as per ECN1195P DD verified by:EC Est Rev:F 08-06-04 Added QC8 JLM Verified By:EC

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M6061T6R0750



6061-T6 Round Bar .750"





Comment: Qty.:

Total: 10.5000 f(s) 0.1050 f(s)/Unit

6061-T6 Round Bar .750"

Material: 6061-T6 (QQ-A-225/8) Ø0.75 Rod

(M6061T6R0.750)

2.0

HARDINGE





Comment: HARDINGE CNC LATHE SMALL

Make as per Dwg D2057 and Folio FA260.

Break all sharp edges 0.015 max.Do not drill Ø0.191

QC2



Comment: INSPECT PARTS AS THEY COME OFF MACHINE





QC8

SECOND CHECK

4.0

3.0



Comment: SECOND CHECK

5.0

PACKAGING 1

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Dart Aerospace Ltd

W/O:			WORK ORDER	CHANGES					
DATE	STEP	PRO	OCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector
				-					
Part No	:	PAR #:	Fault Category:	NCR	: Yes	No DQ	A:	Date: _	
					QA:	N/C Close	d:	Date: _	

	WORK ORDER NON-CONFORMANCE (NCR)								
	Description of NC		Corrective Action Section B	Varification	Amminum	Annroyal			
STEP	Section A	Initial Chief Eng	Action Description Chief Eng Sign & Section C Date			Chief Eng	Approval QC Inspector		
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	STEP	STED Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Section A Initial Action Description	STEP Description of NC Section A Initial Action Description Sign &	STEP Section A Initial Action Description Sign & Section C	STEP Description of NC Section A Portion Description Section B Section B Verification Approval Chief Eng		

NOTE: Date & initial all entries

Date: User:

Thursday, 12/06/2008 9:46:03 AM

Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 39826

Part Number: D2057

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE





Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Aerospace Ltd

W/O:			WORK ORDER	CHANGES					
DATE	STEP	PRO	CEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Category:	NCR:	: Yes	No DQ	A:	Date:	
					QA: I	N/C Close	d:	Date:	······································

	WORK ORDER NON-CONFORMANCE (NCR)								
	Description of NC		Corrective Action Section B	Varification	Ammerical	Anneousel			
STEP	Section A	InitialAction DescriptionSign &Chief EngChief EngDate		Section C	Chief Eng	Approval QC Inspector			
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	STEP	STEP Description of NC Section A	STEP Description of NC Section A Initial Chief Eng	STEP Description of NC Section A Chief Eng Chief Eng Chief Eng	STEP Description of NC Section A Initial Chief Eng Chief	STEP Description of NC Section A Chief Eng Corrective Action Section B Sign & Date Section C Sec	STEP Description of NC Section A Initial Chief Eng Chi		

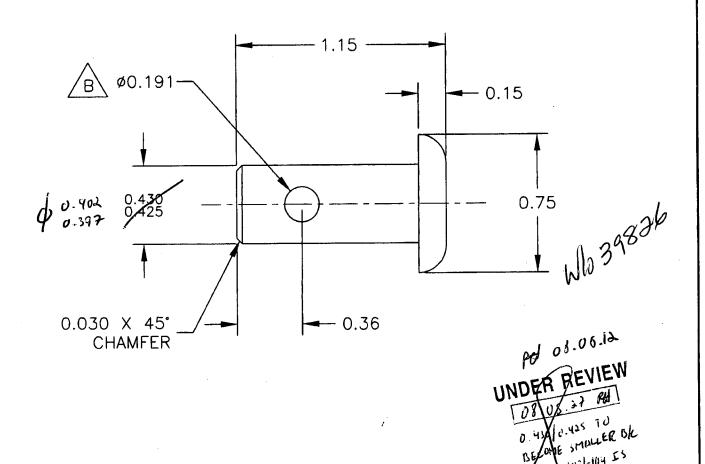
NOTE: Date & initial all entries



DESIGN DRAWN BY			DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHEC	KED _	APPROVED	DRAWING NO. REV. B
	MA-	\$E	D2057 SHEET 1 OF 1
DATE	<u> </u>		TITLE SCALE
98.	10.15		PLUG 2:1
Α		92.03.13	NEW ISSUE
В		98.10.15	REDRAWN 0.191 DIA WAS 0.187 DIA (TSR A1100)

CHANGENG IS

RELEASED 98.10.16 PS



MATERIAL: 6061-T6 ROD (QQ-A-225/8)

FINISH: NONÈ

BREAK ALL SHARP EDGES 0.015 MAX

TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

Dart Aerospace Ltd

W/O:			WORK ORDER CHAI	NGES				
DATE	STEP	PR	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:	Fault Category:	NCR: Yes	No DQ	A :	Date: _	
				QA:	N/C Close	d:	Date: _	

NCR: WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B	Verification	Approval	Annroyal	
DATE	STEP	Section A	Initial Action Description Chief Eng Chief Eng		Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

-DART-AEROSPACE LTD	Work Order:	39876
Description: Plus	Part Number:	129023
Inspection Dwg: \(\)\(\)\(\)\(\)\(\)\(\)\(\)\(\)\(\)\(\		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.15	2.030	1.14	V ,			
0.15	±.030 ±.010 +.403397 ±.010x±5	D-14	J			
Ø .750	± .010	Ø.751	√			
60 P. Q	+.409 - 3977	Ø.400				
.030×45°	±.010x ± 5°	Ø.400 .030×45°				
		,				
				.,		
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Measured by:	MMFDIP	Audited by:	9L.	Prototype Approval:	
Date:	08/16/13	Date:	08/04/13	Date:	

Rev	Date	Change	Revised by	Approved
Α		New Issue	KJ/JLM	

